

Work Order ID 74475

Monday, October 03, 2011 9:44:38 AM



Page 1

Item ID: D2661-2	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Saddle, RH Fwd Aft Out 206					
Start Date: 9/30/2011	Start Qty: 10.00		Cust Item ID:		
Required Date: 10/28/2011	Req'd Qty: 10.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>M.L.J</u>	Date: <u>11/10/03</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2661	Rev D								

100		HAAS CNC VERTICAL MACHINING #1	0.00	<u>20/brk 11/10/26</u>	<u>10</u>			
HAAS 1		Memo	0.00					
HAAS CNC vertical machine #1		Program part number and batch number. <input type="checkbox"/> Fixturing Inspection last completed <u>11/10/26</u> by <u>af</u> <input type="checkbox"/> 1-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet <input type="checkbox"/> 2-Machine Step No 2 of Folio and visually inspect as per attached Dimension						

110		CONVENTIONAL MILLING MACHINE	0.00	<u>20/brk 11/10/26</u>	<u>10</u>			
Mill Conv		Memo	0.00					
Conventional Milling Machine		Machine Keyway and inspect per attached dimension sheet						

120		QC2- Inspect parts off machine FAI/FAIB	0.00	<u>20/brk 11/10/26</u>	<u>10</u>			
QC		Memo	0.00					
Quality Control								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/00/31	100							

NOTE: Date & initial all entries

Work Order ID 74475

Monday, October 03, 2011 9:44:38 AM



Page 2

Item ID: D2661-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

JK 11-10-31

10

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10 BL 11-10-31

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3:45

4:15

10XPM-11/10/31

M117745 3200F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74475

Page 3

Monday, October 03, 2011 9:44:38 AM

Item ID: D2661-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 x d 11/11/01
counted

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/11/01

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/01

ME
11-11-01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 03, 2011 9:44:45 AM

Page 1

Work Order ID: 74475

Parent Item: D2661-2

Parent Item Name: Saddle, RH Fwd Aft Out 206



Start Date: 9/30/2011

Required Date: 10/28/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.11.01 Removed P/O for Powder Coat - in house process EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	73.0000	1	10			

Saddle Billet, 7075

Location	Loc Qty	Loc Code
MAT040	8	
72226	8	
MAT44	65	
72226	5	
73769	60	

74680 X10

OK 11/10/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 74475
Description: 206 Saddle, Outboard, Right side	Part Number: D2661-2
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.132	.130	.130	.130		
B	0.100	0.140		.125	.125	.125	.125		
C	1.250	1.270		1.132	1.136	1.135	1.137		
D	0.615	0.685		.675	.675	.675	.675		
E	0.240	0.260		.251	.249	.250	.249		
F	1.437	1.467		1.323	1.323	1.323	1.323		
G	0.210	0.230		.222	.221	.221	.222		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.572	1.568	1.570	1.571		
K	0.235	0.240		.237	.238	.238	.238		
L	0.100	0.120		.110	.112	.111	.111		
M	0.990	1.010		1.000	.998	.998	.999		
N	0.510	0.515		.512	.512	.512	.512		
O	5.990	6.010		5.998	5.997	5.998	5.997		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.315	.315	.315	.315		
S	0.315	0.322		.317	.317	.317	.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.791	.787	.792	.791		
W	0.540	0.560		.543	.545	.546	.550		
X	1.674	1.684		1.680	1.680	1.680	1.680		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.922	.926	.917	.922		
AA	0.490	0.510		.509	.509	.497	.498		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE				0.466	0.486	OTHER SIDE INDICATED			PTC
AF									
Accept/Reject									

Measured by: <i>amp</i>	Audited by: <i>YL</i>
Date: 11/10/26	Date: 11-10-31



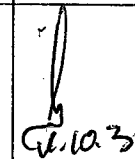
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.10.31	100	CONCERN ON PART SHIFTED WHEN FLIPPING PART TO MACHINE OTHER SIDE. RC 4TH AXIS OFF.	 J.10.31 Q510A2	ACCEPTABLE DEVIATION. PART CAN BE ASSEMBLED ON X-TUBE W/120LTS + 1000G + EDGE DISTANCE PRESERVED	 11/10/31	 J.10.31		
				ED = 1.5 x 0.313 = 0.470				

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 74475
Description: 206 Saddle, Outboard, Right side		Part Number: D2661-2
Inspection Dwg: D2661 Rev. D		Page 1 of: 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	17	18		
A	0.100	0.140		.128	.128	.128	.128		
B	0.100	0.140		.125	.125	.125	.125		
C	1.250	1.270		1.135	1.135	1.136	1.136		
D	0.615	0.685		.675	.675	.675	.675		
E	0.240	0.260		.248	.248	.248	.248		
F	1.437	1.467		1.323	1.323	1.323	1.323		
G	0.210	0.230		.223	.223	.223	.223		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.570	1.571	1.571	1.571		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.110	.110	.110	.110		
M	0.990	1.010		.998	.998	.998	.998		
N	0.510	0.515		.572	.572	.572	.572		
O	5.990	6.010		5.997	5.997	5.997	5.997		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.315	.315	.315	.315		
S	0.315	0.322		.317	.317	.317	.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.791	.791	.791	.791		
W	0.540	0.560		.552	.552	.552	.552		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.920	.920	.920	.920		
AA	0.490	0.510		.497	.497	.497	.497		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>one</i>
Date: 11/10/26

Audited by: <i>J</i>
Date: 11-10-31

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD		Work Order: 74475
Description: 206 Saddle, Outboard, Right side		Part Number: D2661-2
Inspection Dwg: D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	19	210	3	4		
A	0.100	0.140		.128	.128				
B	0.100	0.140		.125	.125				
C	1.250	1.270		1.135	1.135				
D	0.615	0.685		.675	.675				
E	0.240	0.260		.248	.248				
F	1.437	1.467		1.323	1.323				
G	0.210	0.230		.223	.223				
H	0.100	0.180		.140	.140				
I	2.470	2.510		2.490	2.490				
J	1.565	1.585		1.570	1.570				
K	0.235	0.240		.238	.238				
L	0.100	0.120		.110	.110				
M	0.990	1.010		.998	.998				
N	0.510	0.515		.572	.572				
O	5.990	6.010		5.997	5.997				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.313	0.318		.315	.315				
S	0.315	0.322		.317	.317				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.362	1.362				
V	0.787	0.807		.791	.791				
W	0.540	0.560		.552	.552				
X	1.674	1.684		1.679	1.679				
Y	0.257	0.262		.258	.258				
Z	0.912	0.932		.920	.920				
AA	0.490	0.510		.497	.497				
AB	0.178	0.198		.188	.188				
AC									
AD									
AE									
AF									
Accept/Reject									

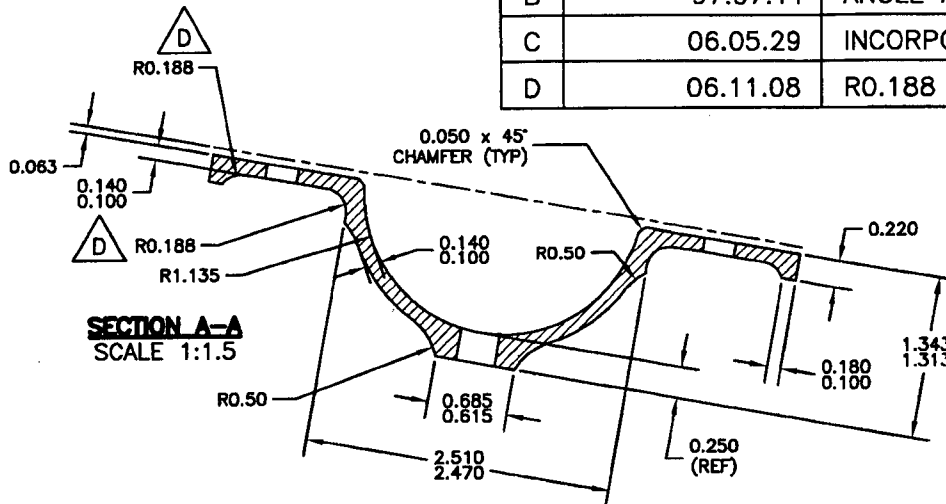
Measured by: <u>RF</u>
Date: <u>11-10-27</u>

Audited by: <u>JL</u>
Date: <u>11-10-31</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

DESIGN #1	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #1	DRAWING NO. D2661	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE OUTSIDE		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	



RELEASED

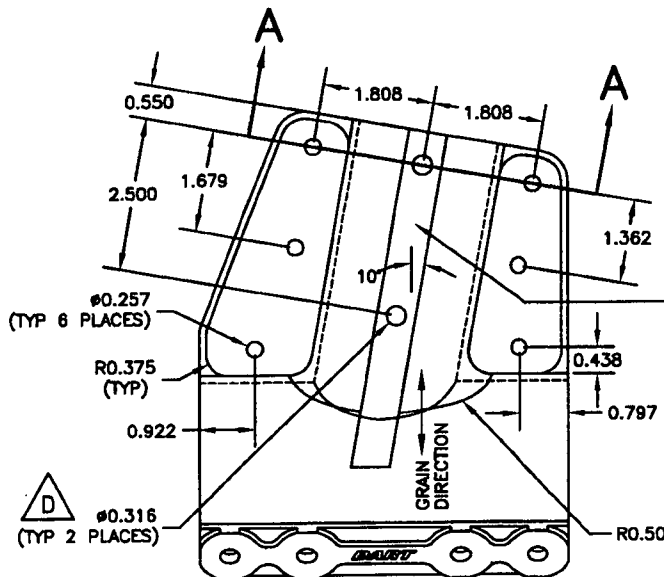
07/02/03 COPY #1

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

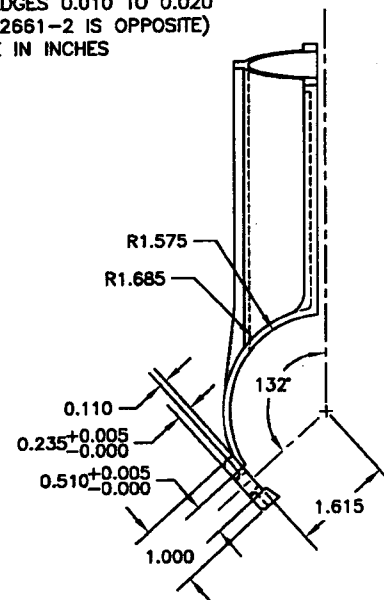
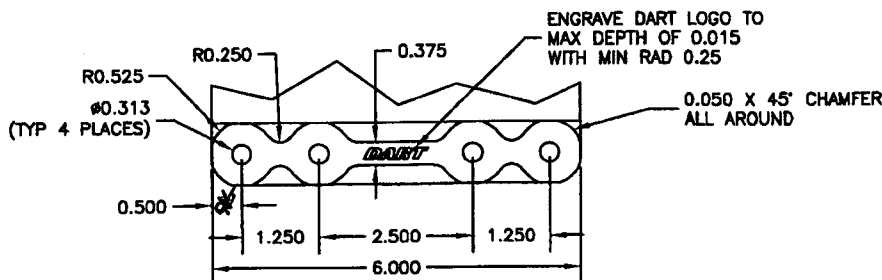
WITHOUT NOTICE
WORK ORDER
NO. 74475 M.L.J
11/10/03

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (DQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010

**D2661-1 SADDLE OUTSIDE**

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries